





P41123PC002

Certified in accordance to Pressure Equipment Directive 97/23/EC Annex I,  
Paragraph 4.3 by TÜV Anlagentechnik GmbH (Notified Body Identification No. 0035)  
Inspection Certificate EN10204-3.1B

<b>Taiyuan Iron and Steel(Group)Co.,LTD</b> NO.2 jiancaoping, Taiyuan, Shanxi, P.R.China TEL: (0351)3013328 FAX: (0351)3017816 http://www.tisco.com.cn E_mail: tgbxg@tisco.com.cn				<b>INSPECTION CERTIFICATE</b>							
				MATERIAL		AISI304 No.2B Finish					
				SPECIFICATION		ASTM A240/A480 ASME SA240/SA480					
				L/C NO.							
				CERTIFICATE NO.		200412110					
		DATE OF ISSUE		/ /							
CUSTOMER				CONTRACT NO.		DATA OF					
Marubeni-Itochu Steel CA.				Y-947		2004/12/20					
Product		Melting furnace		Inspectors stamp		Mark of the Manufacturer					
COIL		E+VOD				Shanxi Taiyuan Stainless Steel Co.,ltd					
NO.	Heat No.	Coil No.	Quantity	Dimensions		Weight (kg)					
1	4405025	4A11-303-12B	1	11GA x 48 x C		4358					
2	4404509	4A10-356-12B	1	14GA x 48 x C		3920					
3	QHLL0164	4A12-141-3ZJ	1	14GA x 48 x C		4972					
4	Y408037	4A12-373-4ZD	1	12GA x 48 x C		4382					
5	Y408037	4A12-374-4ZD	1	12GA x 48 x C		4347					
6	Y408037	4A12-375-4ZD	1	12GA x 48 x C		4257					
7	4405608	4A12-341-1ZJ	1	12GA x 48 x C		3793					
Chemical Composition											
Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
4405025	0.060	0.470	1.340	0.020	0.002	18.050	8.100				0.059
4404509	0.050	0.470	1.350	0.021	0.002	18.080	8.120				0.060
QHLL0164	0.052	0.546	1.077	0.027	0.003	18.300	8.080				0.044
Y408037	0.063	0.550	0.980	0.030	0.002	18.320	8.170				0.060
Y408037	0.063	0.550	0.980	0.030	0.002	18.320	8.170				0.060
Y408037	0.063	0.550	0.980	0.030	0.002	18.320	8.170				0.060
4405608	0.060	0.510	1.350	0.021	0.002	18.090	8.100				0.055
Mechanical Properties											
Test No.	Tensile R <sub>m</sub> N/mm <sup>2</sup>	R <sub>p0.2</sub> Yield <sub>0.2%</sub> N/mm <sup>2</sup>	R <sub>p1.0</sub> Yield <sub>1.0%</sub> N/mm <sup>2</sup>	Elongation A5%	Corrosion Tests	Hardness					
						HRB	HV	HRC			
4405025-T	610	255		65		83					
4404509-T	655	265		61.5		84					
QHLL0164-T	660	275		58.5		83					
Y408037-T	660	260		64		85					
Y408037-T	660	260		64		85					
Y408037-T	660	260		64		85					
4405608-T	665	265		61.5		84					
Surface and dimensions controlled:											
Work Inspector: 											

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Sep 01, 2005  
10:49 am

Work Order No : 0024171  
Project Name : D3405-041  
Project For : ~~GHW LUG~~ *Wk539*  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3405-041  
Description : Lug Assembly  
Manufactured : No  
Amount Req'd : *0*  
Amount Done : *0*  
Start Date : 08-31-05  
Est Finish Date : 09-29-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

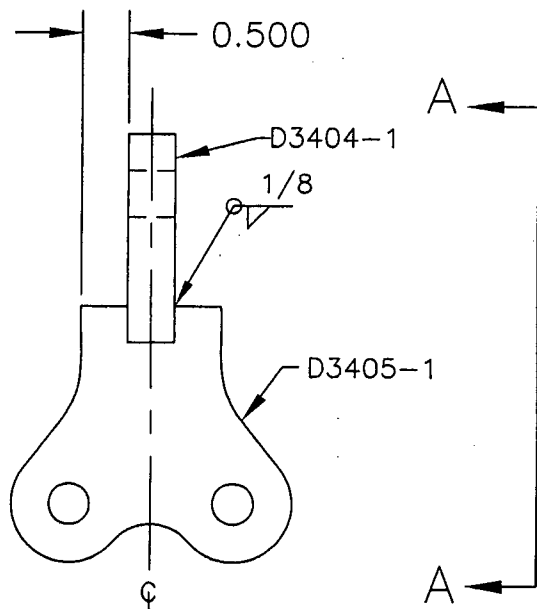
Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

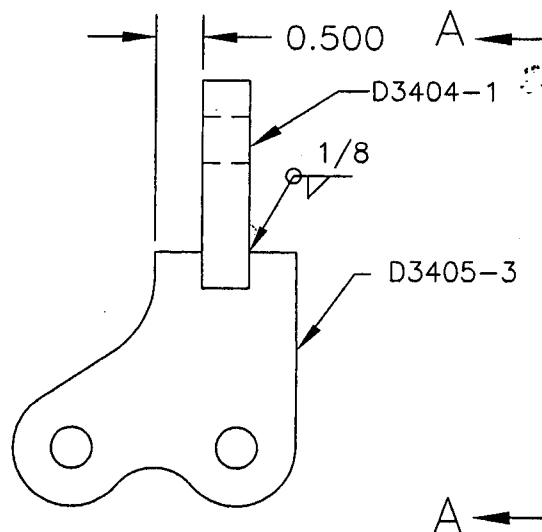
	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3405	REV. A SHEET 1 OF 2
DATE 05.03.08		TITLE GHW LUG ASSEMBLY	SCALE 1:2
A	05.03.08	NEW ISSUE	



**D3405-041 LUG ASSEMBLY**



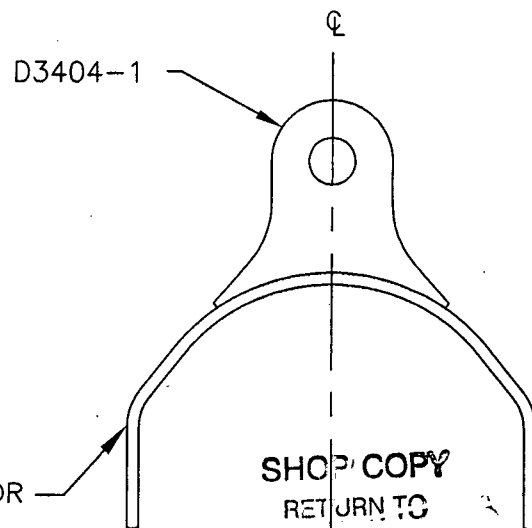
**D3405-043 LUG ASSEMBLY**

**PARTS LIST FOR D3405-041/-043 LUG ASSEMBLY**

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3405-041	LUG ASSEMBLY
	X	D3405-043	LUG ASSEMBLY
1	1	D3404-1	GHW LUG
1		D3405-1	GHW BRACKET
	1	D3405-3	GHW BRACKET

**RELEASED**  
05-08-09 *[Signature]*

D3405-1 OR  
D3405-3



**SHOP COPY**  
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ENGINEERING

**UNVIEW ROLLAD COPY**  
SUBMIT TO AMENDMENT  
WITHOUT NOTICE

**WORK ORDER**

NO. 24171

**D3405-041/-043 LUG ASSEMBLY**


- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT ASSEMBLY WHITE PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT CENTERLINES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 05/10/26

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	24171
<b>Description:</b> Lug Assembly		<b>Part Number:</b>	D3405-041
<b>Dwg:</b> D3405 Rev. A		<b>Qty:</b>	8 4
<b>Ref:</b>		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	AL	05/09/07	8
2	PG	Issue P/O: <u>2008729</u> Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3405 Material release note is required Identify as D3405-1	AL	05/09/30	8
3	RG	Receive and Inspect for transit damage Enure material release note is attached	CL	05/10/18	8
4	QC6	Inspect dimensions as per Dwg D3405	J	05-10-18	8
5	GA	Deburr	N/A		
6	GB	Form using DT8204 as per Dwg D3405	SB	05/10/19	8
7	QC5	Inspect work to Step 6	J	05-10-19	8
8	WS	Weld as per Dwg D3405 Pick: Qty Part number Description Batch 1 D3404-1 Lug 324611 A/R SS Rod 113066 Identify as D3405-041	CL	05-10-24	8
9	QC9	Visual welding inspection	AL	05/10/24	8
10	QC5	Inspect work to Step 9	AL	05/10/24	8
11	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	W/L	05 10 25	8
12	QC3	Inspect Powder Coat	CL	05/10/25	8
13	ST	Identify and Stock	PO	05/10/25	8
14	AC	Cost / part: <u>35.45</u>	SAC	05-10-26	8
15	DC	Close W/O <u>35.45</u> Inspect Level 21	CL	05/10/26	8

Rev	Date	Change	Revised By	Approved
A	05.09.01	New issue	KJ/JLM	

**RELEASED**  
11/05/01